

Monday, 4/24/2006 10:22:26 AM
Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT STEP ASSEMBLY (206/407)
Job Number	: 26753A		
Estimate Number	: 11775		
P.O. Number	: N/A	Part Number	: D2842042
This Issue	: 4/24/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2842 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: B
	Type : LARGE FAB ASSY	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 5/10/2006
Checked & Approved By	: <u>06.04.24</u>	Qty:	2 Um: Each
Comment	: Est Rev:D As Per Ecn 766 06-01-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<u>324563</u>

Check Material for any Dents or Defects

06.05.02 2

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842

2-Drill D2842-1 using Jig DT8272 as per Dwg D2842

3-Deburr and bevel ends for welding

06.05.02 2

06.05.02 2

06.05.03 2

3.0	D2734	206 Step Endplate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<u>324402</u>

06.05.03 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 26753A

Part Number: D2842042

Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D2776

Step Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Step Lug

Pick:

Qty Part Number Description Batch

2 D2776Lug

325430

RF 06-05-03

P.T.O

2

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld one end cap and (2) lugs using Jig DT

followed by DT

as per Dwg D2842

A/R

AL Rod

Batch: M18838

RF 06-05-04

2

2-Grind end cap weld flush

FF 06-05-04

2

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

RF 06-05-06 (2)
DL 06/05/08 (2)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DL 06/05/08 (2)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PD 06-05-09

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove alodine prior to welding.

Weld end cap as per Dwg D2842.

A/R

AL Rod

Batch: M15689

RF 06-05-09

2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-05-03	4.0	Pick Qty 2 D3459-3 Description lug B <u>25430</u>	PE	06-05-03	2	PE	
	4.6	Pick Qty 2 D3459-1 Description lug B <u>25429</u>	PE	06-05-03	2	PE	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PE Date: 06/06/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date: Monday, 4/24/2006 10:22:26 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 26753A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Grind end cap weld flush.

10.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

06-05-09
DD 06-05-09

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine end cap and Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/05/09

12.0

NAS1329C3KB130

insert



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)

Insert

Pick:

Qty Part Number

Description Batch

3

NAS1329C3KB130 Insert

M100034

13.0

MS27039C107

screw



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

MS27039C1-07

Screw

M19522

14.0

NAS1515H3L

WASHER



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

3

NAS1515H3L

WASHER

M19185

15.0

AN960C10L

washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

AN960C10L

WASHER

M18822

DL 06/05/11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *DP* Date: 06/06/05

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Date: Monday, 4/24/2006 10:22:26 AM
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Process Sheet

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Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 26753A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: LARGE FABRICATION RESOURCE 1
1-Install inserts as per Dwg D2842

DC 06/05/11

(2)

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch: M100652

air 06-05-10

(2)

17.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

06-05-15 (2)

(2)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

M/2

06/07/15

(2)

19.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

06/06/05 (2)

Job Completion



06-06-05

Dart Aerospace Ltd

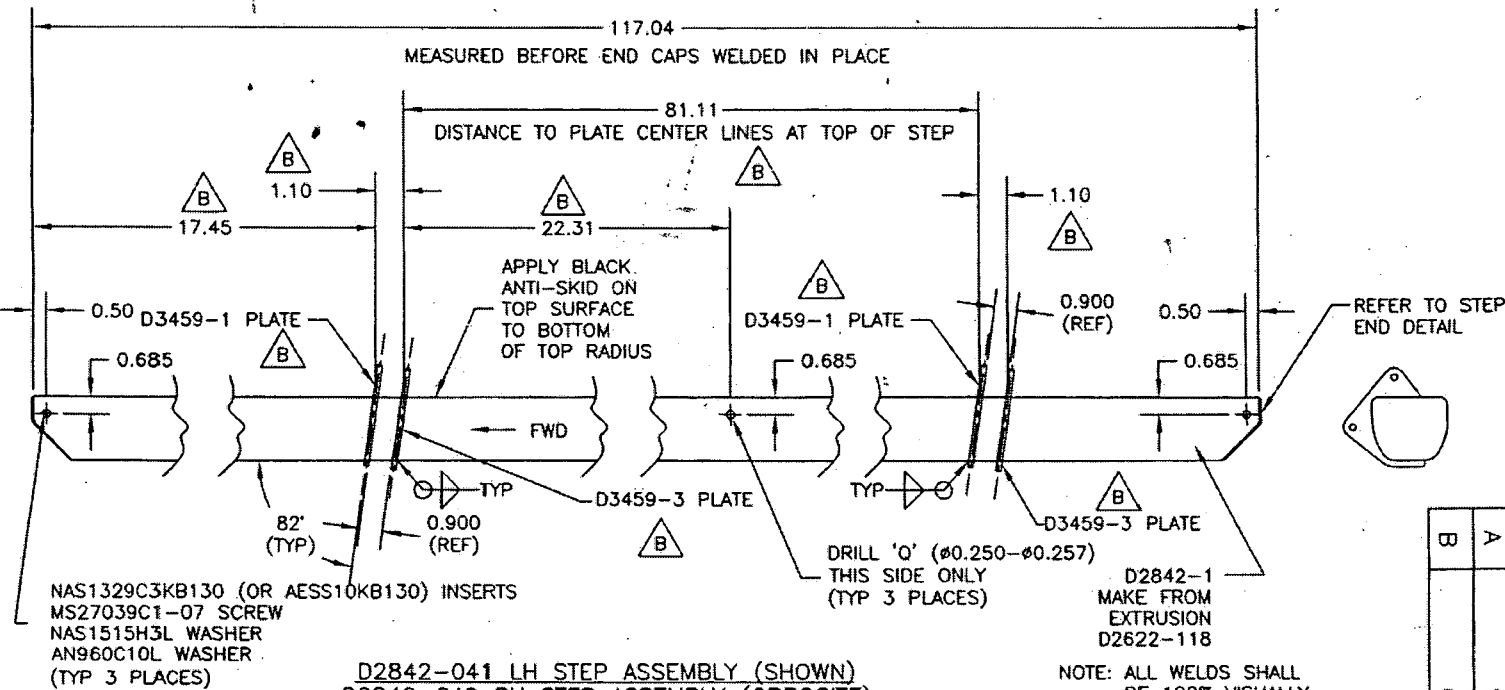
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

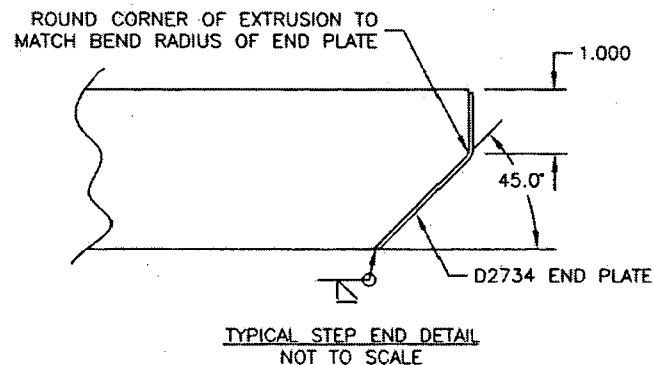
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NOTE: Date & initial all entries

DART



D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2642-041	LH STEP ASSEMBLY
	X	D2642-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN560C10L	WASHER



D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA		REV. 8
CHECKED 	APPROVED 	DRAWING NO. D2842	SHEET 1 OF 1	
DATE 05.09.23	TITLE 206L/407 FLOAT STEP ASSEMBLY		SCALE NTS	
A	98.10.13	NEW ISSUE		
B	05.09.23	RE-DESIGN, ADD D3459-1/-3		

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RELEASED
05-11-14 10:00 AM

26753A